

# Work Order ID 78579

**\*78579\***

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Wednesday, January 11, 2012 12:47:16 PM

Item ID: D3589-9

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: FWD GUIDE PLATE

Start Date: 1/11/2012 Start Qty: 10.00 **\*10\***

Cust Item ID:

Required Date: 1/13/2012 Req'd Qty: 10.00 **\*10\***

Customer:

Reference:

Approvals: Process Plan: MF Date: 12-01-11

Tooling:

Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3589	Rev B

100 0.00

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3589

Prog Rev: B

Dwg Rev: B

Deburr as required

B12-1-11

(B)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

**\*110\***

QC

Memo

0.00

Quality Control

B12-1-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 78579

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Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: FWD GUIDE PLATE

Start Date: 1/11/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 1/13/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: W/A

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

MF  
12-01-12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

# Picklist Print

Wednesday, January 11, 2012 12:47:16 P

Page 1

Work Order ID: 78579

Parent Item: D3589-9

Parent Item Name: FWD GUIDE PLATE

Start Date: 1/11/2012

Required Date: 1/13/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-06-05 new issue DD verified by:ec  
dwg DD verified by:EC

IPP Rev:B 09-02-20 rev.b as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased		No		100	sf	99.3300	0.06	0.6315789	1.	1/12-1-11	

Location

Loc Qty

Loc Code

MAT020

99.33

119346

31.5

119653

67.83

119346

13

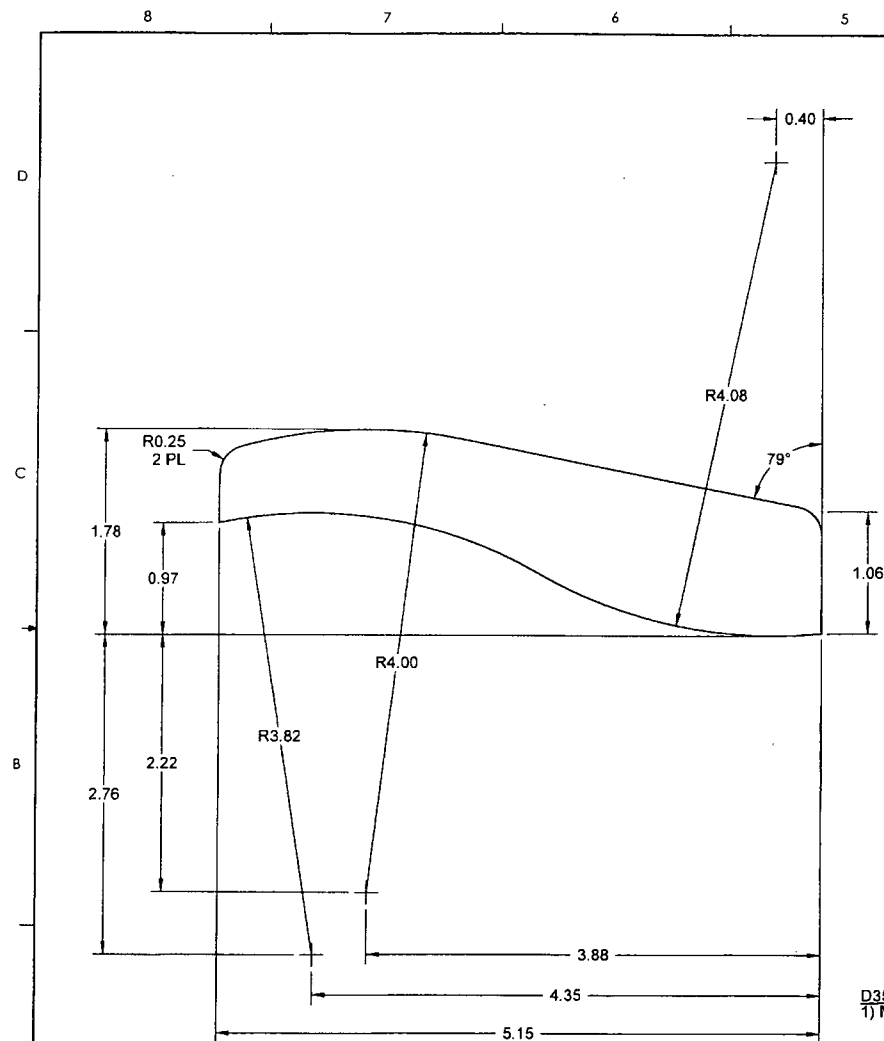
W/O:		WORK ORDER CHANGES					
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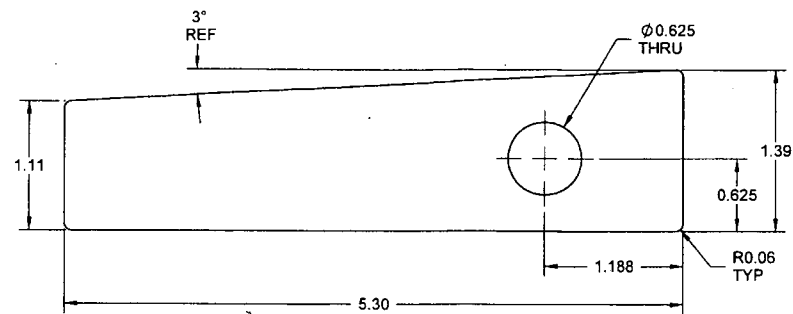
NOTE: Date & initial all entries



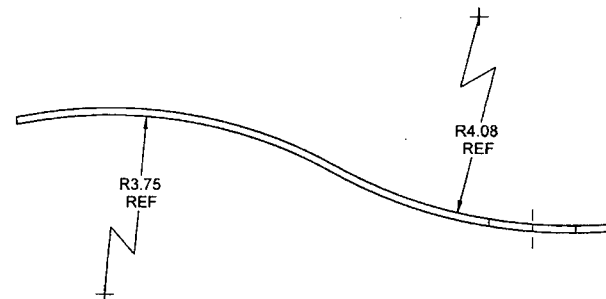
**D3589-9 FORWARD GUIDE PLATE**

**D3589-9/-11/-11F NOTES:**  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET,  
 PER AMS 5513 OR AMS 5524,  
 OR MIL-S-5059 (ANNEALED) 2B FINISH  
 16 GAUGE (0.063 THICK)  
 (REF. DART SPEC M304S16GA)

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 LBS EACH
- 8) CONTROL SHAPE PER DT9021 TEMPLATE



**D3589-11F FORWARD GUIDE PLATE**  
**FLAT PATTERN**



**D3589-11 FORWARD GUIDE PLATE**  
 (MAKE FROM D3589-11F)

**RELEASED**  
 09/24/05

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3589</b>	SHEET 6 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>FORWARD GUIDE PLATE</b>	NTS
DATE	<b>08.06.25</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 7879
<b>Description:</b> Fwd Guide Plate		<b>Part Number:</b> D3589-9
<b>Inspection Dwg:</b> D3589	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.06	+/-0.030	1.06	✓		V BCL	
5.15	+/-0.030	5.155	✓		V	
1.78	+/-0.030	1.78	✓		V	
0.063	+/-0.010	0.057	✓		V	

<b>Measured by:</b> IB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-1-11	<b>Date:</b> 12/01/12	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.07	New Issue	KJ/EC	 

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